

Work Order ID 52926

October 19, 2009 10:57:29 AM

Page 1

Item ID: D3957-043

Accept

Setup Start

Revision ID: A

Stop

Item Name: Hinge Assembly, Door LH Lower

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *RI*

Date: 09-10-19

Tooling:

Date:

Run Start




QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3957	A								
100	Pick Kit	0.00							
									
Packaging									
Packaging	Memo	0.00							
110		0.00							
									
Small Fab									
Small Fab	Memo	0.00							
	1-Install Helicoil in d3957-3								
	2-Install Rod end and Nut Loosely								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC									
Quality Control	Memo	0.00							

M-L 09/11/12

6X

= 7 M-L 09/11/12

6X

6

10-11-13

Work Order ID 52926

Page 2

October 19, 2009 10:57:29 AM

Item ID: D3957-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Assembly, Door LH Lower

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/11/13 SQ (62)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/16 JF
ME
09-11-16

Picklist Print

October 19, 2009 10:57:57 AM

Page 1

Work Order ID: 52926

Parent Item: D3957-043A-PRELIM

Parent Item Name: Hinge Assembly, Door LH Lower


Start Date: 10/19/09

Required Date: 11/02/09

Comments:


Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3518-3RevB  Stainless Steel Ball Joint Rod End		Manufactured	No			100	Each	18.0000	4.0000			*


Warehouse	Loc Qty	Loc Code
Location B51108		
Main Warehouse		
ST 51180	3	
48211	3	
Main Warehouse B53439		
ST109	15	
51108	5	
52270	10	

M-k 09/11/12
4X 6X

MS124818  Helicoil		Purchased	No			100	Each	50.0000	4.0000			*
--	--	-----------	----	--	--	-----	------	---------	--------	--	--	---

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	50	
112503	50	

M-k 09/11/12
4X 6X

D3957-3A-PRELIM  Hinge, Door LH Lower		Manufactured	No			100	Each	0.0000	4.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

B 53439

6X M-k 09/11/12

Picklist Print

October 19, 2009 10:57:57 AM

Page 2

Work Order ID: 52926

Parent Item: D3957-043A-PRELIM

Parent Item Name: Hinge Assembly, Door LH Lower

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6		Purchased	No			100	Each	18.0000	4.0000			



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

112492

10

M. L. Oaluliz

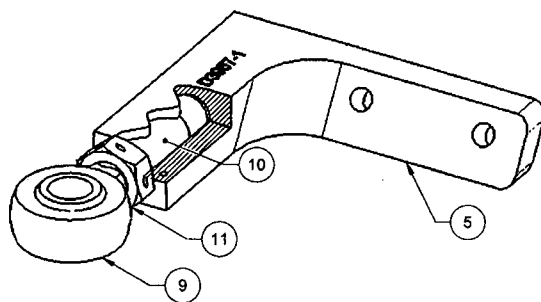
~~5X~~ 6X

October 19, 2009 10:57:57 AM

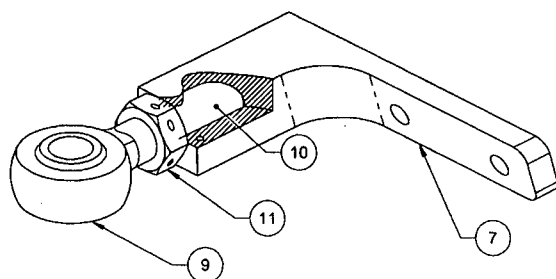
Shop Packet Print

Page 2

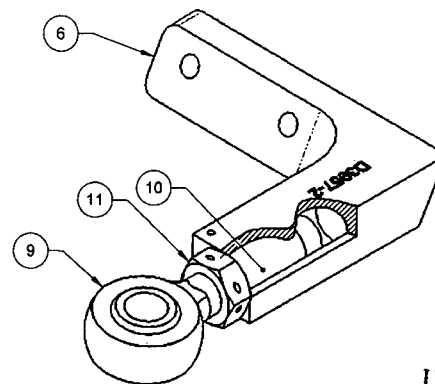
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



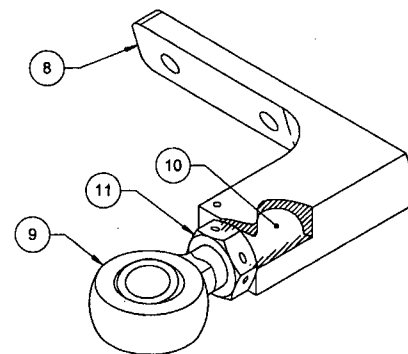
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

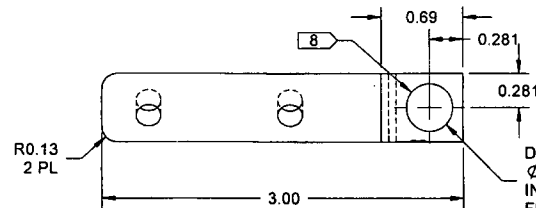
SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57924
2009-10-15

RELEASED
2009-10-08
MD

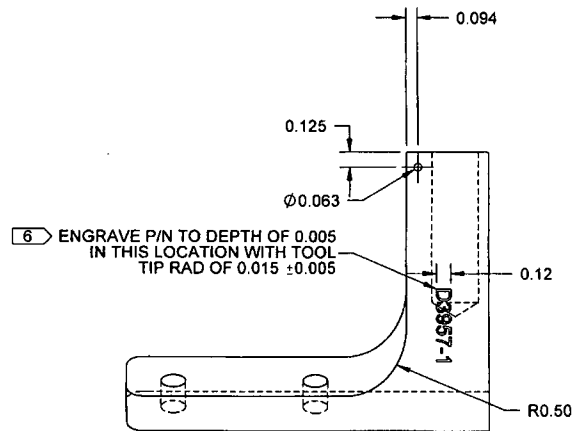
A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A SHEET 1 OF 5
TITLE HINGE	SCALE NTS

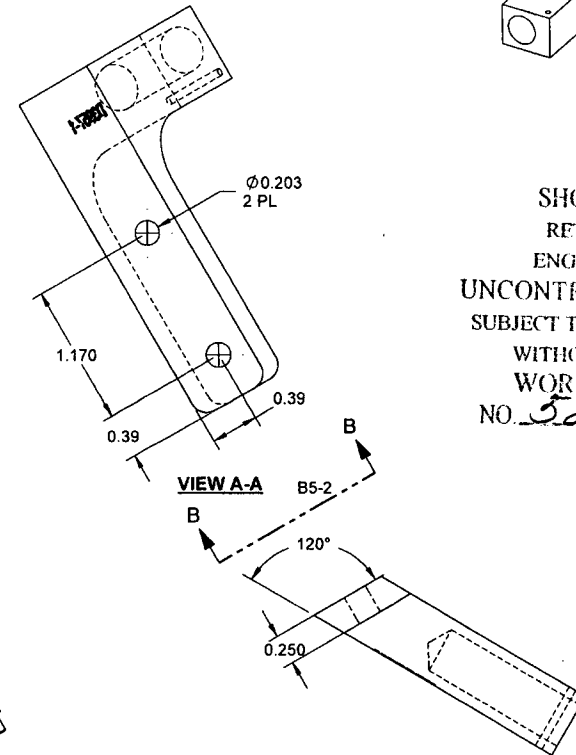
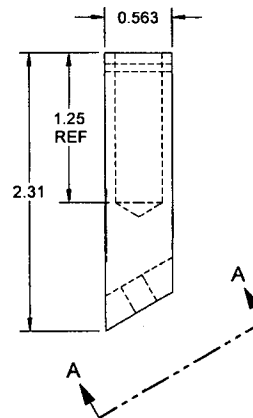
COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\Phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW A-A

VIEW B-B

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO A REVISED
 WITHOUT A NEW
 WORK ORDER
 NO. 52926

D3957-1 HINGE, DOOR LH UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

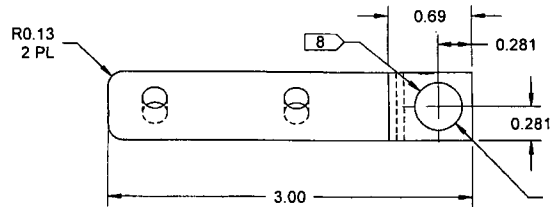
DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 2 OF 5
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

C3-2

RELEASE
 2009-10-08

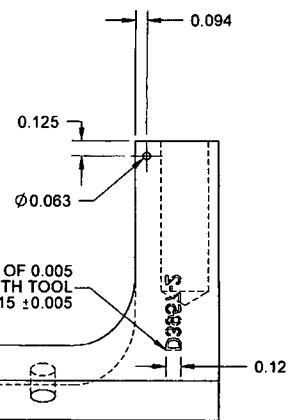
8 7 6 5 4 3 2 1

D

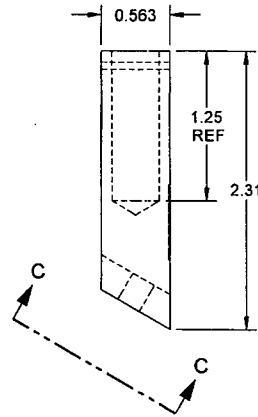


DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE

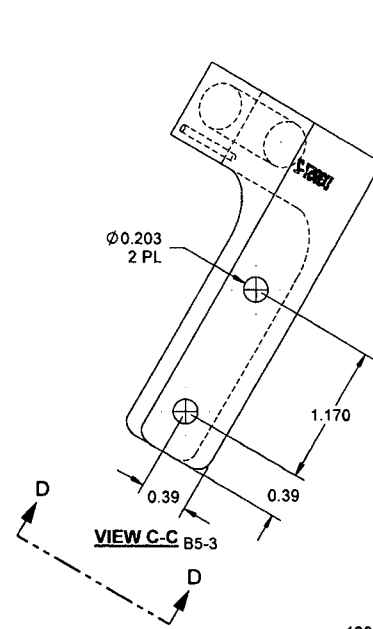
C



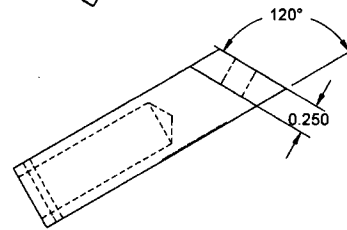
6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



D3957-2 HINGE, DOOR RH UPPER

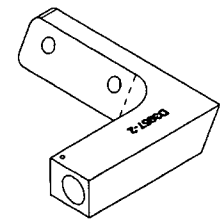


VIEW C-C B5-3



VIEW D-D

C3-3



SHOP COPY
 RETURN TO
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO A REVISED
 WITHOUT NOTICE
 WORK ORDER
 NO. 39926

RELEASED
 2009 -10- 0 8

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

A

R0.13
2 PL

8

0.69

0.281

0.281

3.00

DRILL AND TAP FOR 3/8-24 HELICAL INSERT
Ø0.391 X 1.25 DP
INSTALL HELICOIL MS124818
FLUSH WITH SURFACE

0.125

0.094

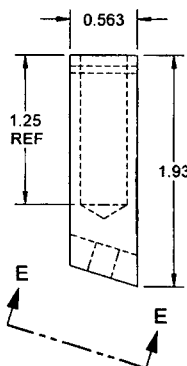
Ø0.063

6 ENGRAVE P/N TO DEPTH OF 0.005
IN THIS LOCATION WITH TOOL
TIP RAD OF 0.015 ±0.005

0.12

0.12

R0.50



Ø0.203
2 PL

1.170

F

0.33

0.39

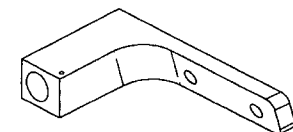
VIEW E-E B5-4 F

F

107°

0.250

VIEW F-F C3-4



SHOP ONLY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO A
WITHOUT A
52926

RELEASED
2009-10-08

D3957-3 HINGE, DOOR LH LOWER

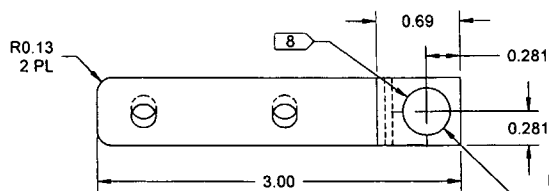
NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

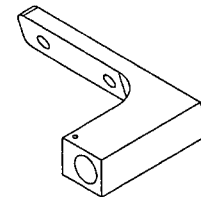
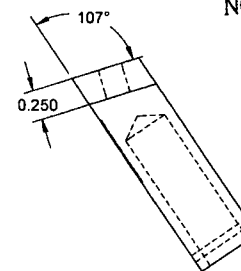
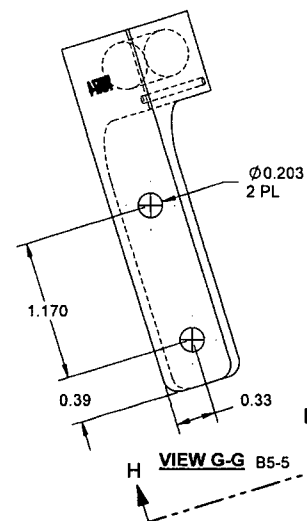
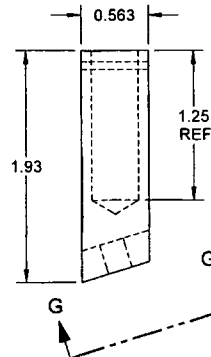
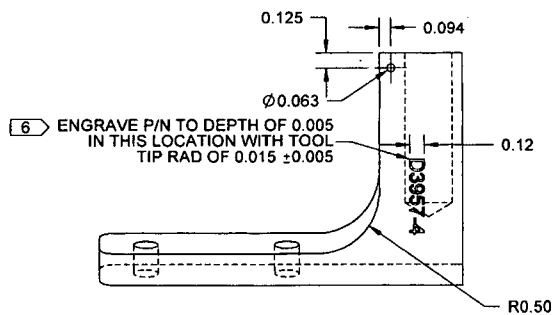
DESIGN	85	DART AEROSPACE LTD	
DRAWN	85	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 4 OF 5
APPROVED	42	TITLE	SCALE
DE APPR.	42	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE









SHOP COPY
 RET.
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO A WORK ORDER
 WITHOUT A WORK ORDER
 NO. 52926

D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08
 [Signature]

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1